

Work Order ID 51824

September 4, 2009 8:43:04 AM



213/ ASA P
214 ASA P

Page 1

Item ID: D3847-11 *GY* Accept

Revision ID: B

Item Name: WEARPAD

Start Date: 09/04/2009 Start Qty: 16.00

Required Date: 09/11/2009 Req'd Qty: 16.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *mf* Date: *09-09-04* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3847	B

100

0.00



Waterjet

FLOW CNC Waterjet

354
-063

Memo

1-Cut as per Dwg D3847

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

0.00

B 9-9-22

(19)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-9-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

2) 802109/22

(XIS)

/

Quality Control

130

Memo
Form as per dwg

0.00



Brake NC

0.00

809/09/24

19

/

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 802109/24

(XIS)

/

Quality Control

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150



Large Fab

Large Fab

Memo

Weld hardcoat as per dwg.

A/R 2059B Batch: M109893

M112272

0.00

0.00

SP 09-10-01
~~SP 09-09-24~~

(19x)

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> S 09/10/02

(X29)

φ

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

=> S 09/10/02

(X29)

φ

QC10
09/10/02

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Item ID:	D3847-11	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	WEARPAD					
Start Date:	09/04/2009	Start Qty: 16.00		Cust Item ID:		
Required Date:	09/11/2009	Req'd Qty: 16.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4-3 <i>M 10/10/09 START 11:45 OVENTE. 320° FINISH 12:15</i> Memo	0.00 0.00				<i>(19)</i>			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>09/10/09</i>		<i>(X19)</i>	<i>Ø</i>		
200 Packaging Packaging	Identify as per dwg & Stock Location: <i>EP-17</i> Memo	0.00 0.00		<i>09/10/09</i>		<i>(X19)</i>	<i>Ø</i>		

W/O:		WORK ORDER CHANGES					
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Setup Start



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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

u 9-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

September 4, 2009 8:43:04 AM

Page 1

Work Order ID: 51824



Parent Item: D3847-11RevB



Parent Item Name: WEARPAD

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	261.2310	2.8514	3,3860		



304/316 Sheet .063



18 9-4-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

261.2309737

106860

16.018

111924

33.0549737

112290

36.8947

112442

79.2633

112567

96

111924

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DART AEROSPACE LTD		Work Order:	51824
Description: WEAR PAD		Part Number:	D3847-11
Inspection Dwg: D3847-11 Rev: B		Page 1 of 1	

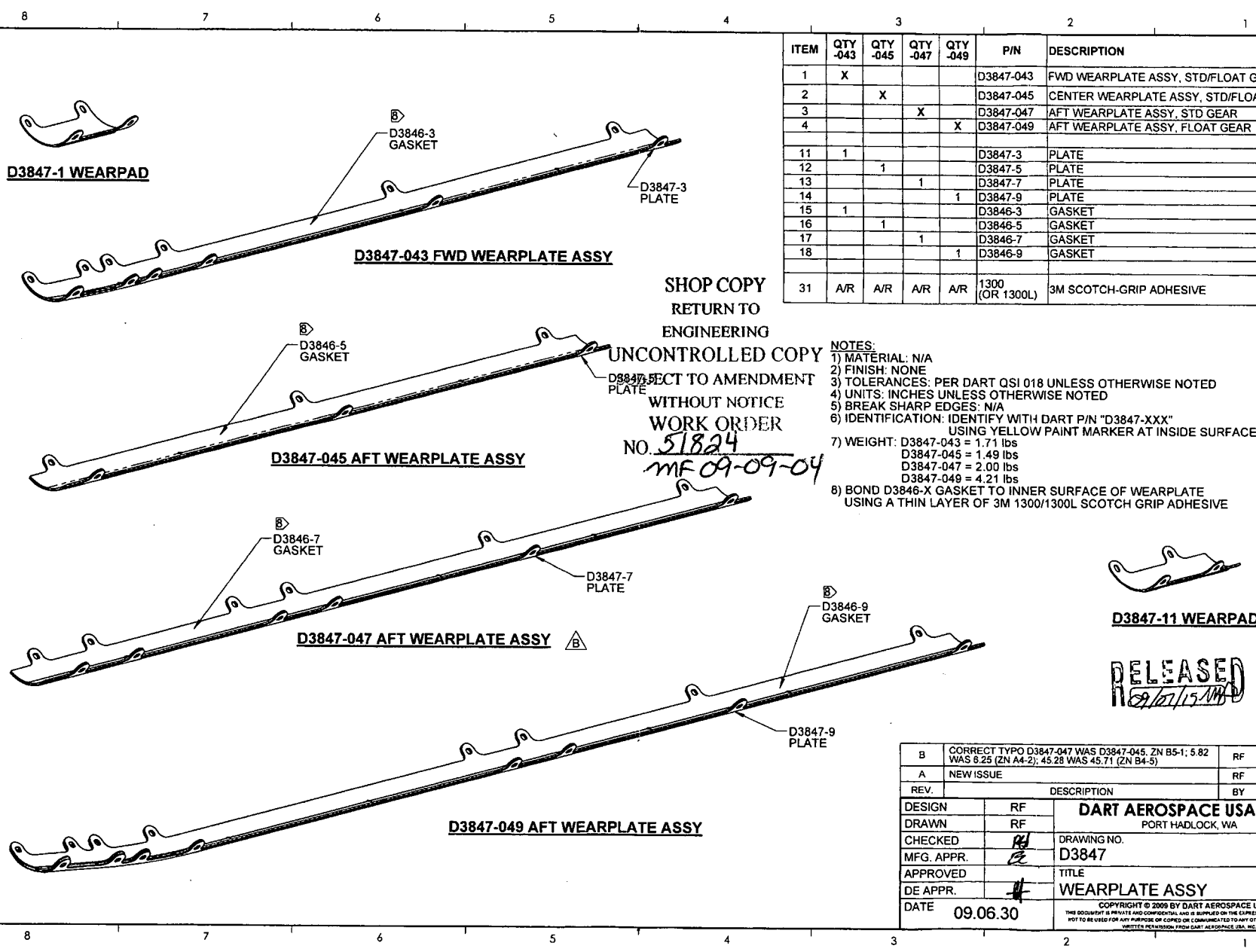
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-9-22	Date:	9/16/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 51824
 MF 09-09-04

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
 - 7) WEIGHT: D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
 - 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

D3847-11 WEARPAD
 RELEASED
 09/07/15

B	CORRECT TYPO D3847-047 WAS D3847-045, ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

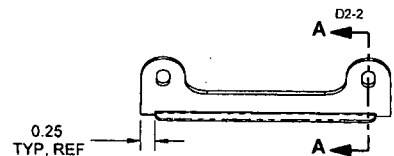
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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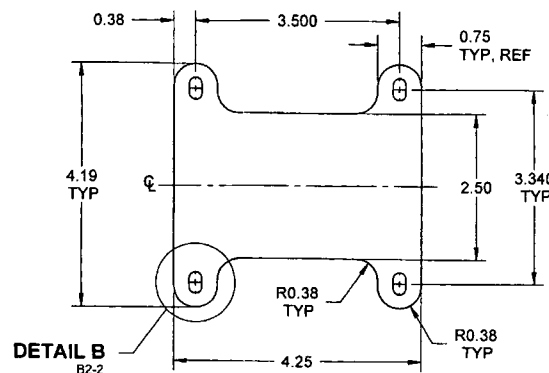
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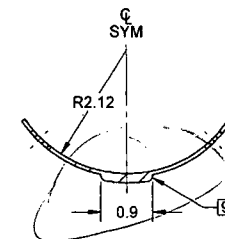
8 7 6 5 4 3 2 1



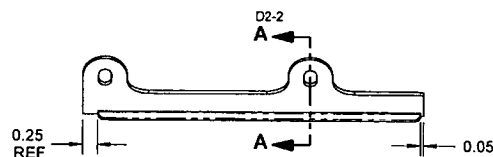
D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN



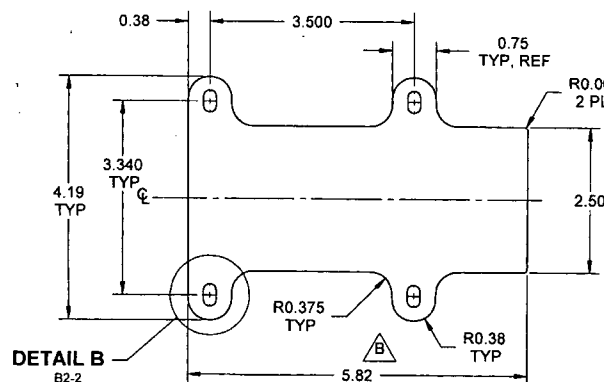
D3847-1F FLAT PATTERN



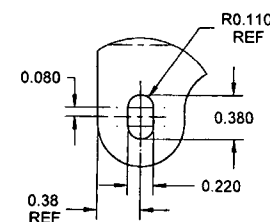
SECTION A-A D7-2 B7-2



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



DETAIL B B5-2
TYP, SCALE 2X

51824

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3847-1 = 0.03 lbs
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 20598 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

RELEASED
2012/11/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	Ad	DRAWING NO.	REV. B
MFG. APPR.	Ex	D3847	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.	11	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

8 7 6 5 4 3 2 1

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